

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003738**Date Inspected:** 31-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2030**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Chen Chih-Ming/Zhao Chen Sun/ <del>Chen Ming-Pang</del>			<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No N/A</b>

**Bridge No:** 34-0006**Component:** OBG side, bottom, deck panels, floor beams, t**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG new assembly bay 2

QA observed ZPMC personnel fitting floor beam 13A @ PP-030 OBG section 5AE.  
QA observed ZPMC qualified welding personnel back gouging deck panel slice on DP-110-002.  
QA observed ZPMC qualified welding personnel 3G SMAW stiffener ends to diaphragm on corner assembly identified as CA5 for OBG section 3BW PP-023.  
QA observed ZPMC qualified welding personnel 3G FCAW north side floor beam splice @ PP-035 OBG section 5CW.

Other general observations include ZPMC personnel fitting and welding OBG east fixture, OBG temporary support columns, grinding and weld bevel prep on various OBG components.

OBG bay 1

QA observed ZPMC personnel fitting u-rib stiffeners to one deck panel. QA also noted that ZPMC completed PJP u-rib to deck plate GMAW and SAW welds on gantry 1 for DP-093-001 and DP-568-001.

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Deck panels DP-415-001 and DP-543-001 are on gantry 2 table ready to be welded.

OBG bay 2

QA noted that there was no CT work in this bay. ZPMC fitting and welding temporary columns

OBG bay 3

QA observed ZPMC personnel preparing parts for fit up and welding; (cutting parts, drilling and weld bevel prep).

QA observed ZPMC qualified welding personnel welding T-stiffeners to SP337 on one of the gantries.

OBG bay 4

QA observed ZPMC qualified welding personnel FCAW welding stiffeners inside of one double diaphragm.

QA observed ZPMC personnel SAW temporary columns and preparing parts for fit up and welding; (cutting parts and weld bevel prep).

### Summary of Conversations:

Only general conversations were held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ryan Smith, (858) 232-6799, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hall,Steven	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar,Robert	QA Reviewer

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